

Date: Monday, 16/10/2006 9:41:10 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 28975	
Estimate Number : 10368	
P.O. Number : N/A	Part Number : D30481
This Issue : 16/10/2006 S.O. No. : N/A	Drawing Number : D3048 REV. A2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A2
Previous Run : 28975	Material : N/A
	Due Date : 20/10/2006
Written By : _____	Qty: 3 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est: A 02.11.19 New issue KJ/RF	
Est Rev: B Now on Waterjet 06-10-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 3.6312 sf(s)/Unit Total : 10.8936 sf(s)
2024-T3 .063 sheet
Material: 2024-T3 (QQ-A-250/4) 0.063 thick
(M2024T3S.063) Batch: m101022 ml 06 10 16

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3048
Dwg Rev: A2
Prog Rev: A2

ml 06 10 16

(3)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



ml 06 10 16

(3)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



2061016 (3)

Comment: SECOND CHECK

*Scrap parts
parts should have
no holes* 8/3 07/10/25

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28975

Part Number: D30481

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC Brake per Dwg D3048

~~B 06/10/23~~ ①

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

~~B 06.10.23~~

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion














IN D7-01.75

Date: Friday, 13/10/2006 1:27:24 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 28975		
Estimate Number	: 10368		
P.O. Number	:	Part Number	: D30481
This Issue	: 13/10/2006 S.O. No. :	Drawing Number	: D3048 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 26910	Material	:
Written By	:	Due Date	: 20/10/2006 Qty: 3 Um: Each
Checked & Approved By	:		
Comment	: Est: A 02.11.19 New issue KJ/RF		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
			
<p>Comment: Qty.: 3.6312 sf(s)/Unit Total : 3.6312 sf(s) 2024-T3 .063 sheet Material: 2024-T3 (QQ-A-250/4) 0.063 thick (M2024T3S.063) Batch: <u>W24892</u></p>			
2.0	SHEAR	SHEAR	
			
<p>Comment: SHEAR Cut blank: 13.935" x 32.500"</p>			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Make part per 1:1 flat pattern on Dwg D3048</p>			
4.0	QC6	DIMENSIONAL CHECK	
			
<p>Comment: DIMENSIONAL CHECK</p>			
5.0	BRAKE NC	NC BRAKE	
			
<p>Comment: NC BRAKE Form on CNC Brake per Dwg D3048</p>			

Date: Friday, 13/10/2006 1:27:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28975

Part Number: D30481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

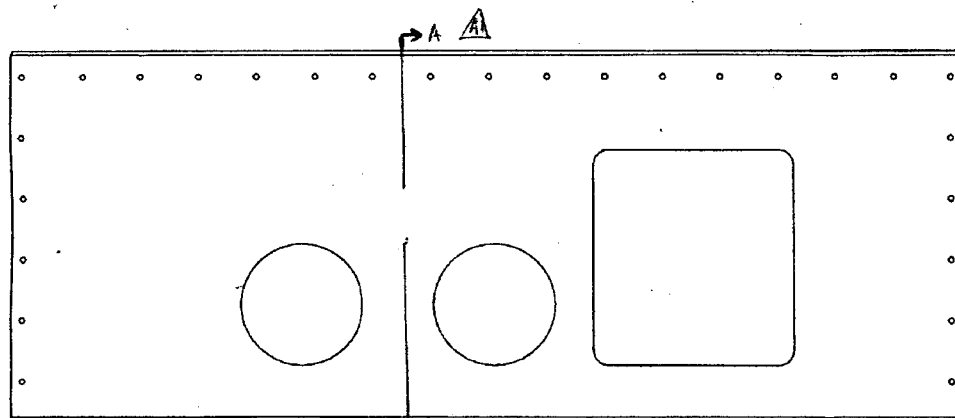
FINAL INSPECTION/W/O RELEASE



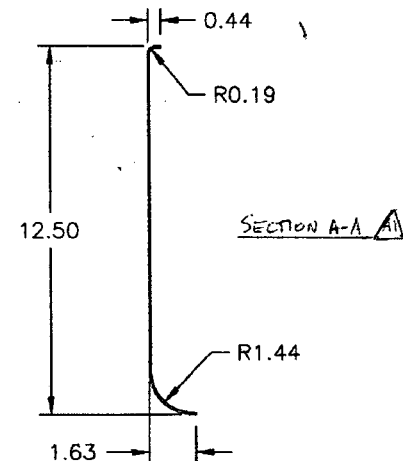
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



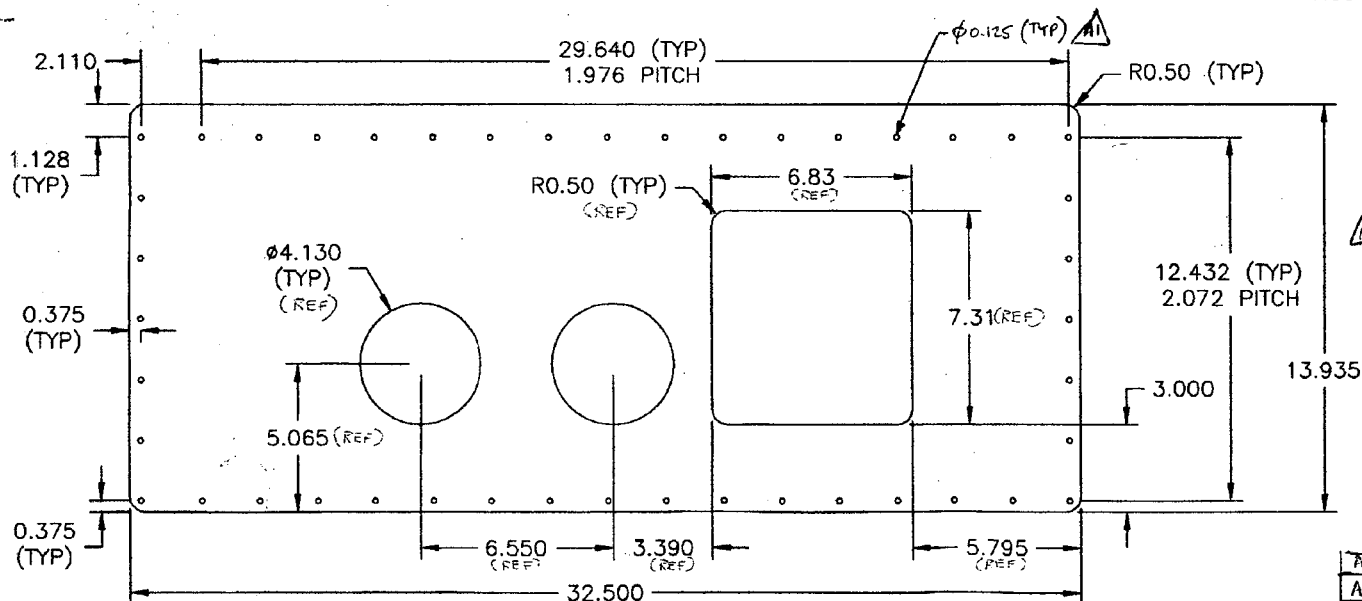


D3048-1



MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

△ CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY,
DO NOT CUT.



D3048-1 FLAT PATTERN

RELEASED
01.09.27

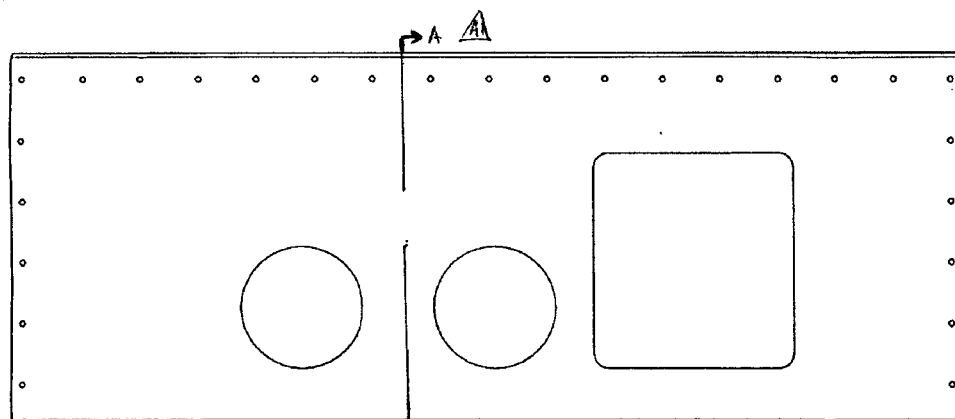
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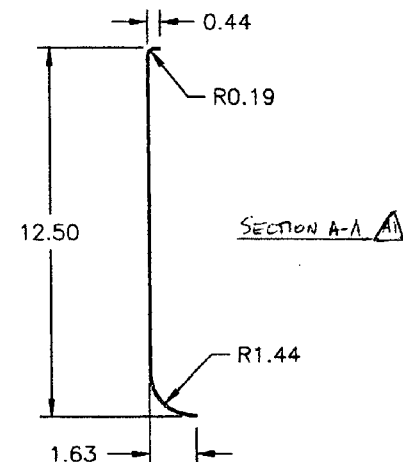
A2	02.11.13	REMOVE CUT-OUTS
A1	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DESIGN	RF	DART
CHECKED	RF	DART AEROSPACE LTD. WARRICKS, ONTARIO, CANADA
DATE	01.09.25	DRAWING NO. D3048
		TITLE DOUBLER

REV. A
SHEET 1 OF 1
SCALE
1:4

REFERENCE ONLY

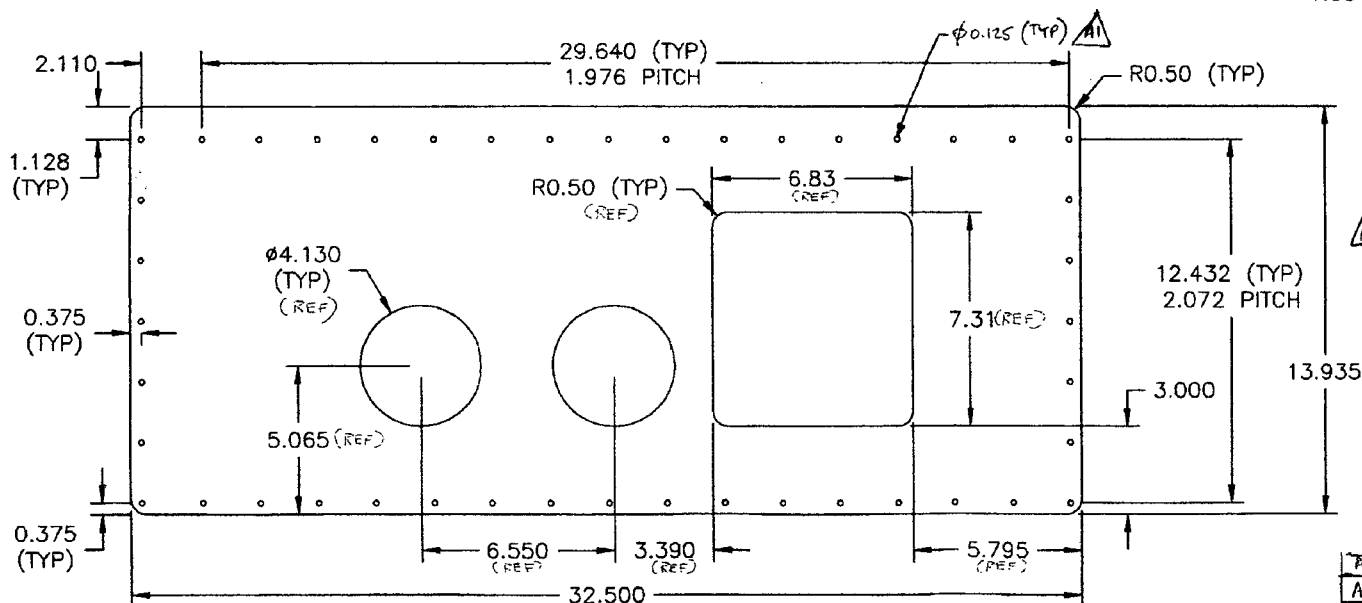


D3048-1



MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

AZ CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY,
DO NOT CUT.



D3048-1 FLAT PATTERN

RELEASED
01.09.27

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DESIGN	4.11.10	REMOVE CUT-OUTS
AI	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DRAWN BY	RF	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3048
DATE	01.09.25	TITLE DOUBLER

REV. A
SHEET 1 OF 1
SCALE
1:4

REFERENCE ONLY

DART AEROSPACE LTD	Work Order: 28975
Description: Doubler	Part Number: D3048-1
Inspection Dwg: D3048 Rev: A	Page 1 of 1

x First Article

[illegible]

Measured by:	<i>[Signature]</i>
Date:	8/10/16